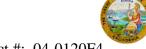
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.21

WELDING WITNESS REPORT

Resident Engineer: Pursell, Gary **Report No:** WWR-000165 Address: 333 Burma Road **Date Inspected:** 29-Mar-2007

City: Oakland, CA 94607

OSM Arrival Time: 800 **Project Name:** SAS Superstructure **OSM Departure Time:** 1530 Prime Contractor: American Bridge/Fluor Enterprises, a JV

Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Contractor: Location:** Shanghai, China

Witness: **Procedure Qualification Record Welder Qualification Fracture Critical**

> Mechnical Testing, describe: all weld metal tension, Welding **NDT**

> > reduced section tension, side bend, charpy (CVN) and groove weld macroetch

specimens.

Index Lot #: B71-019-07a Witness Lot #: B49-020-07 **Bridge No:** 34-0006 **Component:** Bid: 52 Welder: Zhang Xing Jin **ID** #: N/A **Joint Description:** B-U2-S N/A WPS ID #:

PWS-B-T2221-F-5 N/A **Base Metal:** ASTM A709-50F-2 N/A POR ID #: HP200748 N/A Thickness: 26 mm N/A **Process:** SAW N/A Electrode Spec/Class: AWS 5.17/F7A2-EM12K N/A **Positions:** 1-G N/A **Backing Material:** ASTM-A709-50T-2 **CWI:** Huang Wei N/A N/A **AWS Code:** D1.5 2002 **Average Amps:** N/A N/A **Average Volts:** N/A **Applicable Sec:** 5.13 N/A **Travel Speed: Heat Input:** N/A N/A

Preheat: N/A

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector was present as requested by ZPMC Quality Assurance Manager, Mr. Lui Lui to witness the mechanical testing for procedure qualification (PQR) testing of HP200748. The PQR test plate was welded in the 1G position using the submerged arc welding (SAW) process. The SAW welding consumable is identified as a 4.8mm electrode, AWS specification A5.17, classification EM12K and F7A2 type flux. The mechanical testing was performed in accordance with AWS D1.5 section 5.13, figure 5.1 requirements. The weld test specimens appeared to comply with the contract documents.

Summary of Conversations:

At 0900 hours. ZPMC Quality Control Inspector, Mr. Hu Gang met with Caltrans QA and stated that ZPMC would be performing mechanical for PQR HP200748 at 0930 hours. At 0930 hours Caltrans was present to witness the mechanical testing.

WELDING WITNESS REPORT

(Continued Page 2 of 2)

is in general conformance with the contract requirements.

Observed welding, testing or results:

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

| Inspected By: | Hasler,Mike | Quality Assurance Inspector |
|----------------------|----------------|-----------------------------|
| Reviewed By: | McClary, David | QA Reviewer |